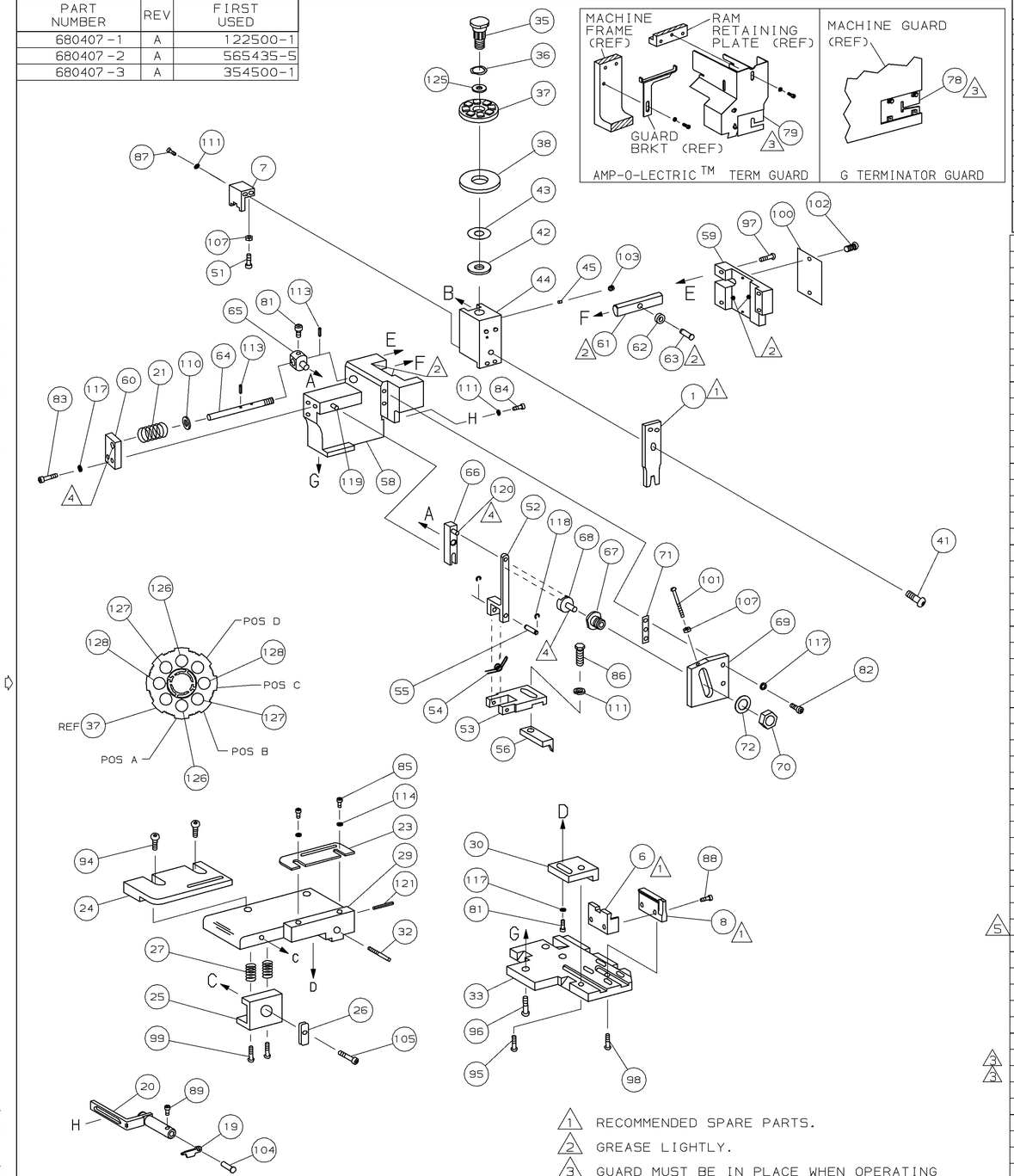
DRAWING MADE IN THIRD ANGLE PROJECTION

680407 ⇔ 680407

/home/amp18717/u.680407

| PART NUMBER | REV | FIRST USED |
|---|---|---|
| 680407-1 | A | 122500-1 |
| 680407-2 | A | 565435-5 |
| 680407-3 | A | 354500-1 |




TERMINAL NAME: CLIP

286537

CRIMPING DATA

| PAD LTR | CRIMP HEIGHT | WIRE SIZE |
|---|---|---|
| A | .083 ±.002 [2.11 ±0.05mm] | 14 |
| B | .074 ±.002 [1.88 ±0.05mm] | 16 |
| C | .069 ±.002 [1.75 ±0.05mm] | 18 |
| D | NOT | USED |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .110 [2.79mm] | F | 18 - 14 |
| INSUL | - | - | - |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|---|---|---|---|---|---|
| - | NONE | 1.00 | 408-8040 | 458637-1 | L1856 |

| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| | | | | | | | 129 |
| 2 | 2 | 2 | - | C | 8-354778-5 | PIN, WIRE DISC (.2920)C | 128 |
| 2 | 2 | 2 | - | C | 7-354778-7 | PIN, WIRE DISC (.2880)B | 127 |
| 2 | 2 | 2 | - | C | 5-354778-9 | PIN, WIRE DISC (.2790)A | 126 |
| 1 | 1 | 1 | - | A | 986950-1 | WASHER, FLAT PRECISION | 125 |
| 1 | 1 | 1 | - | A | 217238-1 | GENERAL INSTRUCTION PACKAGE | 124 |
| 1 | 1 | 1 | - | - | 4088040 | SF APPL INST 408-8040 | 123 |
| | | | | | | | 122 |
| 1 | 1 | 1 | - | A | 3-21028-6 | PIN,SLT SPR(ø.093x.50)ST GDE PL | 121 |
| 1 | 1 | 1 | - | A | 1-21030-1 | PIN,DOWEL(ø.187x.50)LEVER | 120 |
| 1 | 1 | 1 | - | A | 1-21030-6 | PIN,DOWEL(ø.187x1.25)HOUSING | 119 |
| 2 | 2 | 2 | - | A | 21045-3 | RING,RET "C"(ø.187)FD FING PIN | 118 |
| 5 | 5 | 5 | - | A | 21024-5 | WASHER, LOCK(#10)ADJ BLOCK | 117 |
| | | | | | | | 116 |
| | | | | | | | 115 |
| 2 | 2 | 2 | - | A | 21024-2 | WASHER,LOCK(#4)FRONT STP GUIDE | 114 |
| 2 | 2 | 2 | - | A | 5-21028-1 | PIN,SLT SPR(ø.125x.50)ADJ ROD | 113 |
| | | | | | | | 112 |
| 4 | 4 | 4 | - | A | 21024-4 | WASHER,LOCK(#8)STRIPPER | 111 |
| 1 | 1 | 1 | - | A | 21899-4 | WASHER,FLAT(ø5/16)SCREW ADJ | 110 |
| | | | | | | | 109 |
| | | | | | | | 108 |
| 2 | 2 | 2 | - | A | 21018-5 | NUT,HEX(6-32)FEED ADJ | 107 |
| | | | | | | | 106 |
| 1 | 1 | 1 | - | A | 22353-8 | SCR,SHLD(ø.187x.25)DRAG LEVER | 105 |
| 1 | 1 | 1 | - | A | 992031-1 | PIN, CLEVIS | 104 |
| 1 | 1 | 1 | - | A | 21009-2 | SCR,SKT SET(1/4-20x.25 LW)RAM | 103 |
| 2 | 2 | 2 | - | A | 21017-2 | SCR,DRIVE(#2x.19)ID PLATE | 102 |
| 1 | 1 | 1 | - | A | 6-23715-5 | SCR,PAN HD(6-32x1.50)FEED ADJ | 101 |
| 1 | 1 | 1 | - | B | 461264-1 | PLATE, IDENTIFICATION | 100 |
| 2 | 2 | 2 | - | A | 3-21002-0 | SCR,BHC(10-32x.88)DRAG | 99 |
| 1 | 1 | 1 | - | A | 22733-8 | SCR,BHC(8-32x.38 LW)ANVIL | 98 |
| 2 | 2 | 2 | - | A | 2-21002-9 | SCR,BHC(10-32x.75)CAP | 97 |
| 3 | 3 | 3 | - | A | 2-22733-8 | SCR,BHC(1/4-20x.62)HOUSING | 96 |
| 1 | 1 | 1 | - | A | 2-21002-7 | SCR,BHC(10-32x.50)SG ADJ BLOCK | 95 |
| 2 | 2 | 2 | - | A | 2-21002-1 | SCR,BHC(8-32x.38)R ST GUIDE | 94 |
| | | | | | | | 93 |
| | | | | | | | 92 |
| 1 | 1 | 1 | - | A | 1-21002-7 | SCR,BHC(6-32x.38)CAM | 91 |
| | | | | | | | 90 |
| 1 | 1 | 1 | - | A | 7-21000-9 | SCR,SHC(4-40x.19)STRIPPER | 89 |
| 2 | 2 | 2 | - | A | 3-21000-0 | SCR,SHC(8-32x.88)R SHEAR | 88 |
| 5 △ 2 | 2 | 2 | - | A | 3-21000-1 | SCR,SHC(8-32x.92)DEP-HOLD | 87 |
| 1 | 1 | 1 | - | A | 2-22603-0 | SCR,HEX HD(8-32x.31)FEED FINGER | 86 |
| 2 | 2 | 2 | - | A | 1-21000-4 | SCR,SHC(4-40x.38)F ST GUIDE | 85 |
| 1 | 1 | 1 | - | A | 2-21000-7 | SCR,SHC(8-32x.50)STRIPPER | 84 |
| 2 | 2 | 2 | - | A | 3-21000-7 | SCR,SHC(10-32x.75)FEED ROD GD | 83 |
| 2 | 2 | 2 | - | A | 3-21000-6 | SCR,SHC(10-32x.62)FEED ADJ BLK | 82 |
| 2 | 2 | 2 | - | A | 3-21000-4 | SCR,SHC(10-32x.38)SG ADJ BL | 81 |
| | | | | | | | 80 |
| △3 - | REF | - | - | B | 455749-1 | GUARD, WINDOW | 79 |
| △3 REF | - | - | - | B | 679532-7 | INSERT, GUARD | 78 |
| | | | | | | | 77 |
| | | | | | | | 76 |
| | | | | | | | 75 |
| | | | | | | | 74 |
| | | | | | | | 73 |
| 1 | 1 | 1 | - | A | 458109-1 | WASHER, SPECIAL | 72 |
| 1 | 1 | 1 | - | A | 690517-1 | SPACER | 71 |

QTY REQD PER ASSY — PARTS LIST

| -1 | -2 | -3 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| LEADMAKER | BENCH MODEL K | BENCH MODEL G | | | MECH POST FEED | | |
| | | | | | MECH PRE FEED | | |
| | | | | | MECH PRE FEED | | |
| 1 | 1 | 1 | - | B | 22594-8 | NUT,HEX(1/2-20) | 70 |
| 1 | 1 | 1 | - | B | 240628-1 | PLATE, ADJUSTMENT | 69 |
| 1 | 1 | 1 | - | B | 240626-1 | SHAFT, PIVOT | 68 |
| 1 | 1 | 1 | - | B | 240633-1 | BUSHING | 67 |
| 1 | 1 | 1 | - | A | 455680-1 | LEVER, INTERMEDIATE | 66 |
| 1 | 1 | 1 | - | B | 240629-1 | BLOCK, PIVOT | 65 |
| 1 | 1 | 1 | - | A | 240632-2 | SCREW, ADJ FEED ROD | 64 |
| 1 | 1 | 1 | - | B | 240659-3 | PIN, CAM ROLLER | 63 |
| 1 | 1 | 1 | - | B | 240658-1 | ROLLER, CAM | 62 |
| 1 | 1 | 1 | - | B | 454398-2 | ROD, FEED | 61 |
| 1 | 1 | 1 | - | A | 454178-1 | GUIDE, FEED ROD | 60 |
| 1 | 1 | 1 | - | C | 454220-1 | CAP, RAM | 59 |
| 1 | 1 | 1 | - | D | 454485-1 | HOUSING | 58 |
| | | | | | | | 57 |
| 1 | 1 | 1 | - | B | 694433-1 | PAWL, FEED | 56 |
| 1 | 1 | 1 | - | B | 240624-1 | PIN, FEED FINGER | 55 |
| 1 | 1 | 1 | - | B | 691499-1 | SPRING, FEED FINGER | 54 |
| 1 | 1 | 1 | - | A | 690541-1 | HOLDER, FEED FINGER | 53 |
| 1 | 1 | 1 | - | B | 455679-1 | LEVER, TERMINAL FEED ARM | 52 |
| 1 | 1 | 1 | - | A | 811242-2 | BUMPER, HOLDDOWN | 51 |
| | | | | | | | 50 |
| 1 | - | - | - | B | 690602-6 | CAM, PRE-FEED 1 5/8 ST | 49 |
| - | 1 | - | - | B | 690602-5 | CAM, PRE-FEED 1 1/8 ST | 48 |
| - | - | 1 | - | B | 690501-4 | CAM, POST-FEED 1 5/8 ST | 47 |
| | | | | | | | 46 |
| 1 | 1 | 1 | - | A | 690191-1 | PLUG, NYLON | 45 |
| 1 | 1 | 1 | - | C | 455673-1 | RAM | 44 |
| 1 | 1 | 1 | - | A | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 1 | 1 | - | A | 690124-1 | WASHER, RAM | 42 |
| 1 | 1 | 1 | - | A | 7-21002-7 | BOLT, CRIMPER(5/16x.75) | 41 |
| | | | | | | | 40 |
| | | | | | | | 39 |
| 1 | 1 | 1 | - | A | 690223-2 | SPACER, INSULATION DISC | 38 |
| 1 | 1 | 1 | - | D | 354777-1 | WIRE DISC, PLASTIC | 37 |
| 1 | 1 | 1 | - | A | 22480-5 | WASHER, SPRING | 36 |
| 1 | 1 | 1 | - | B | 690212-1 | POST, RAM | 35 |
| | | | | | | | 34 |
| 1 | 1 | 1 | - | D | 904014-1 | PLATE, BASE | 33 |
| 1 | 1 | 1 | - | A | 690432-3 | SCREW, ADJUSTMENT | 32 |
| | | | | | | | 31 |
| 1 | 1 | 1 | - | B | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 1 | 1 | - | C | 3-458144-6 | PLATE, STRIP GUIDE | 29 |
| | | | | | | | 28 |
| 2 | 2 | 2 | - | A | 1-22284-0 | SPRING, DRAG | 27 |
| 1 | 1 | 1 | - | B | 240793-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1 | 1 | - | B | 2-690754-4 | DRAG, TERMINAL | 25 |
| 1 | 1 | 1 | - | D | 1-690748-0 | GUIDE, STRIP (REAR) | 24 |
| 1 | 1 | 1 | - | A | 1-690487-3 | GUIDE, STRIP (FRONT) | 23 |
| | | | | | | | 22 |
| 1 | 1 | 1 | - | A | 4-22284-9 | SPRING, FEED RETURN | 21 |
| 1 | 1 | 1 | - | A | 679218-1 | STRIPPER WIRE STOP ASSY | 20 |
| 1 | 1 | 1 | - | B | 458949-1 | STRIPPER | 19 |
| | | | | | | | 18 |
| | | | | | | | 17 |
| | | | | | | | 16 |
| | | | | | | | 15 |
| | | | | | | | 14 |
| | | | | | | | 13 |
| | | | | | | | 12 |
| | | | | | | | 11 |
| | | | | | | | 10 |
| | | | | | | | 9 |
| △1 1 | 1 | 1 | - | C | 904011-1 | ANVIL | 8 |
| △1 1 | 1 | 1 | - | C | 904010-1 | BLADE, SLUG | 7 |
| △1 1 | 1 | 1 | - | C | 904009-1 | SHEAR, REAR | 6 |
| | | | | | | | 5 |
| | | | | | | | 4 |
| | | | | | | | 3 |
| | | | | | | | 2 |
| △1 1 | 1 | 1 | - | C | 4-456408-1 | CRIMPER, WIRE | 1 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |

← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

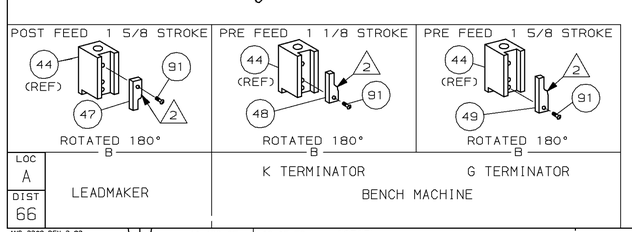
△1 RECOMMENDED SPARE PARTS.

△2 GREASE LIGHTLY.

△3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

△4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.

△5 CUT TO LENGTH AT ASSY




| P | F | LTR | REVISION RECORD | APP | DATE |
|---|---|---|---|---|---|
| | | A | revised | JB | 4-97 |

DIMENSIONS IN INCHES.
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
2 PLC DEC ±-
3 PLC DEC ±-
4 PLC DEC ±-
ANGLES ± -
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

| | | | |
|---|---|---|---|
| MATL - - | HT TR - - | FIN - - | |
| DR 30JAN97 J.C.BAKER | APP 4 FEB 97 T.ELBIN | AMP Incorporated Harrisburg, PA 17105-3608 | |
| CHK 4 FEB 97 C.ERISMAN | REL - - | | |
| NAME SIDE FEED HDM APPLICATOR | | MACHINE REF MINI APPL | |
| SCALE - | D | DWG NO 680407 | SHEET 1 OF 1 | REV A |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